

# Work Order ID 73847

Friday, September 16, 2011 12:46:59 PM

Page 1

Item ID: D2662-1

Accept

Revision ID:

Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00

Required Date: 10/21/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed 11/09/26 by B.A. ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73847

Friday, September 16, 2011 12:46:59 PM



Page 2

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

*only 11/09/27*

*10*



QC Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish Memo

0.00

Hand Finishing

*10X Ø M-L 11/09/28*

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat Memo

0.00

Powder Coating

START TIME: *9:00* □ OVEN TEMPERATURE:  
FINISH TIME: *9:30*

*10X Ø M-L 11/10/03*

*M 118434*

*320 OF*

*9:30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73847

Friday, September 16, 2011 12:46:59 PM



Page 3

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

10 BR 11-10-3

170 Identify as per dwg & Stock Location: 435 0.00



Packaging Memo 0.00

Packaging

11/10/38 (10)

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/10/5 ME 11-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 16, 2011 12:46:57 PM

Page 1

Work Order ID: 73847



Parent Item: D2662-1



Parent Item Name: Saddle, LH In 206


Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C000.06.22 Removed P/O for powder coat EC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	49.0000	1	10		11.9.25	

Location

Loc Qty

Loc Code

MAT040

49

64777

20

66965

1

69677

2

70976

10

72225

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 73847
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page 1 of 3</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.113	0.114	0.113	0.113	Mic	GA-03
B	0.100	0.140		0.133	0.137	0.137	0.137	Mic	118-120
C	1.125	1.145		1.139	1.140	1.139	1.139	Dial	HAASZ
D	0.615	0.685		0.685	0.685	0.685	0.685	Vern	GA-01
E	0.240	0.260		0.246	0.248	0.248	0.248	"	"
F	1.313	1.343		1.322	1.325	1.325	1.325	H-6	31006
G	0.210	0.230		0.219	0.221	0.220	0.221	Vern	GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	"	"
I	2.470	2.510		2.490	2.490	2.490	2.490	"	"
J	1.565	1.585		1.580	1.580	1.581	1.581	Dial	HAASZ
K	0.235	0.240		0.238	0.238	0.238	0.238	Vern	GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	D-6	GA-08
M	0.990	1.010		0.992	0.992	0.992	0.992	Vern	GA-01
N	0.510	0.515		0.514	0.514	0.514	0.514	"	"
O	5.990	6.010		6.000	6.000	6.000	6.000	"	"
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.313	0.318		0.315	0.315	0.315	0.315	"	"
S	0.315	0.322		0.317	0.317	0.317	0.317	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.362	1.362	"	"
V	0.787	0.807		0.792	0.792	0.792	0.792	"	"
W	0.540	0.560		0.550	0.550	0.550	0.550	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.258	0.258	0.258	0.258	"	"
Z	0.912	0.932		0.923	0.923	0.923	0.923	"	"
AA	0.490	0.510		0.500	0.500	0.500	0.500	"	"
AB	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: BA	Audited by: [Signature]
Date: 11/09/26 11.9.27	Date: 11/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 73847
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page</b> 2 <b>of</b> 8

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	26	17	18	By	Date
A	0.100	0.140		.113	.113	.113	.113		
B	0.100	0.140		.138	.138	.138	.138		
C	1.125	1.145		1.139	1.139	1.139	1.139		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		.247	.247	.246	.247		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.210	0.230		.219	.219	.219	.219		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.580	1.580	1.580	1.580		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.992	0.992	0.992	0.992		
N	0.510	0.515		0.514	0.514	0.514	0.514		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.792	0.792	0.792	0.792		
W	0.540	0.560		0.550	0.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.923	0.923	0.923	0.923		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	G.A. <i>GA</i>
Date:	11/09/26 11.9.27

Audited by:	<i>amf</i>
Date:	11/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	73 847
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 3 of 3	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	1	4	By	Date
A	0.100	0.140	29.02	.113	.113				
B	0.100	0.140		.138	.138				
C	1.125	1.145		1.139	1.139				
D	0.615	0.685		.685	.685				
E	0.240	0.260		.246	.246				
F	1.313	1.343		1.322	1.322				
G	0.210	0.230		.219	.219				
H	0.100	0.180		.135	.135				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.580	1.580				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.110	.110				
M	0.990	1.010		.992	.992				
N	0.510	0.515		.514	.514				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.315	.315				
S	0.315	0.322		.317	.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.792	.792				
W	0.540	0.560		.550	.550				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.923	.923				
AA	0.490	0.510		.500	.500				
AB	0.178	0.198	"	.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	29
Date:	11.9.27

Audited by:	GRX
Date:	11/09/27

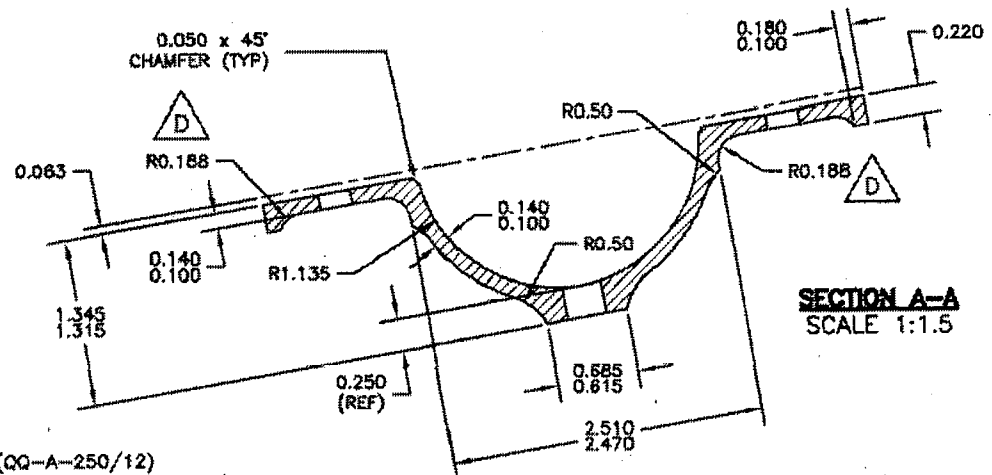
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

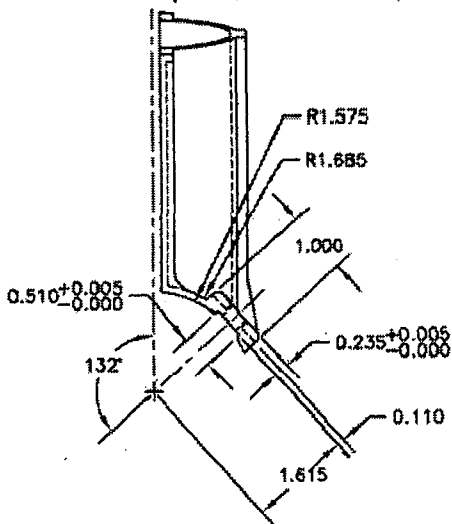
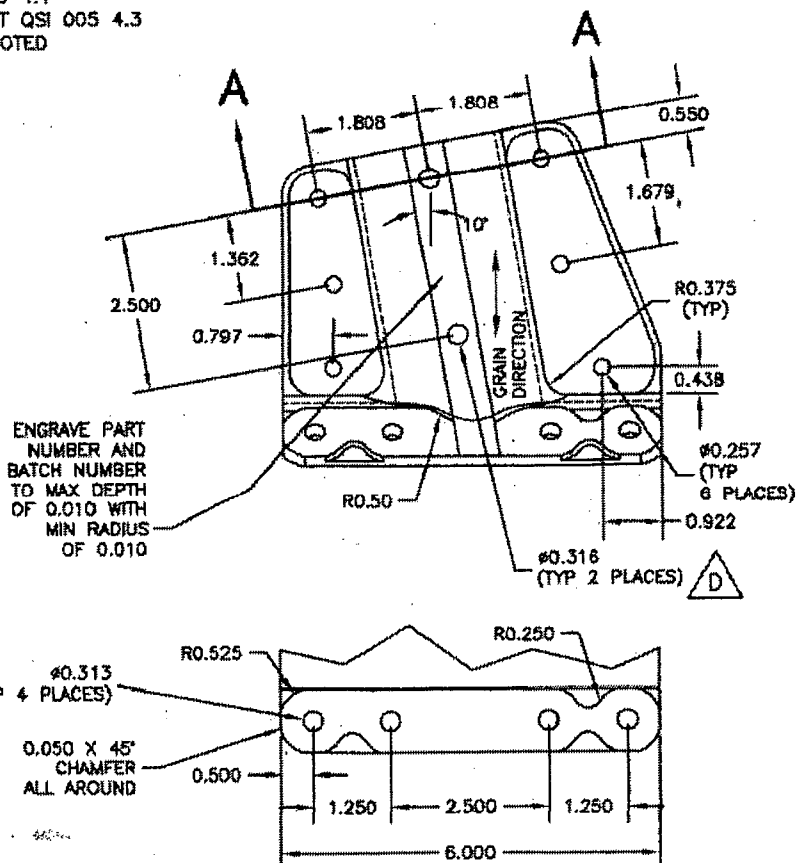
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.02

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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